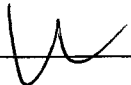


Date: Thursday, 29/05/2008 9:50:46 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT PAN
Job Number	: 37875		
Estimate Number	: 11092		
P.O. Number	:	Part Number	: D30221
This Issue	: 29/05/2008 S.O. No. :	Drawing Number	: D3022 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37875	Material	:
Written By	: 	Due Date	: 05/06/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est. C 02.01.23 Revised NG Est Rev:D 08-04-16 now water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



Comment: Qty.: 1.7044 sf(s)/Unit Total : 1.7044 sf(s)
 2024-T3 .032 sheet
 Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
 Batch: 106272 IB 8-5-29

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3022
 Dwg Rev: A IB 8-5-29
 Prog Rev: A
 *** grind direction along 31.700" ***

2-Deburr if necessary IB 8-5-29

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

no holes.

808/05/29 CL

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form as per Dwg D3022

IB 08/05/29 (1)

Date: Thursday, 29/05/2008 9:50:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 37875

Part Number: D30221

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/06/10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Transfer drill Seat Pan From Frame

*****Transfer drill in D3022-1 using D3017-041 *****

2-Deburr

PD 08-06-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/06/10

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/10 (1)

10.0

POWDER COATING

POWDER COATING



M105642



(1X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:10
320°F
1:40

M. 08/06/10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/10 (1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/06/11 (1)

Date: Thursday, 29/05/2008 9:50:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 37875

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

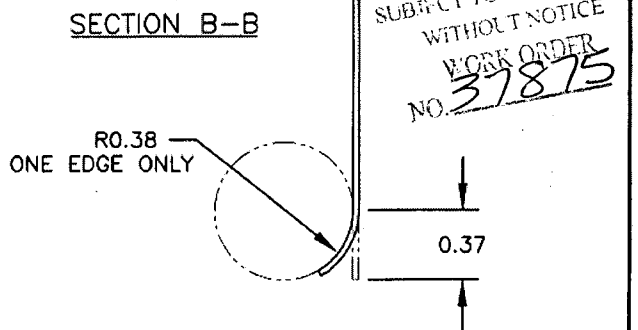
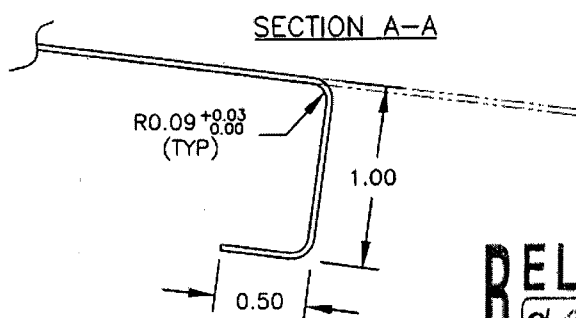
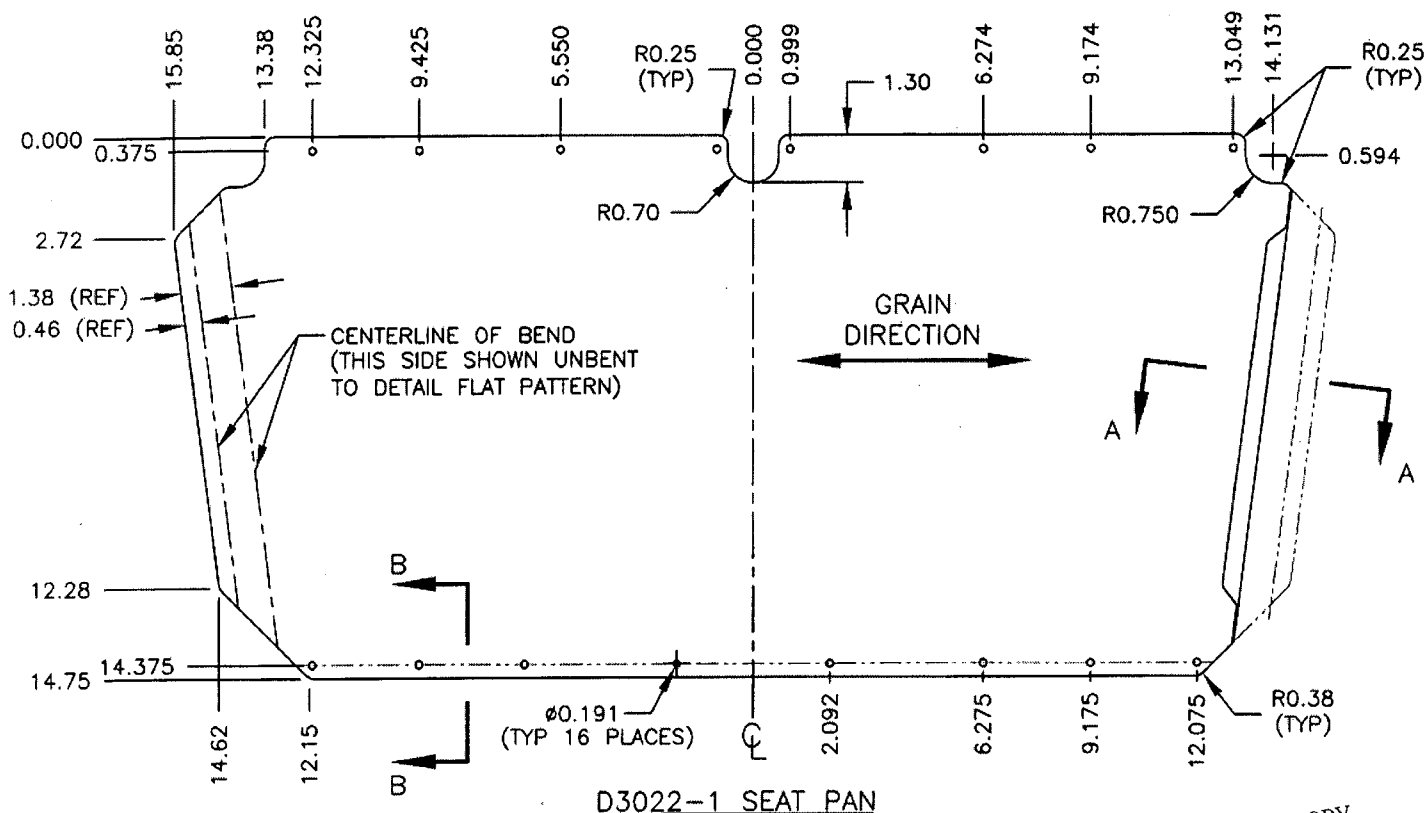
Job Completion



MF 08-06-12



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3022	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE SEAT PAN	SCALE 1:5
A	01.05.18	NEW ISSUE	



RELEASED
02.07

NOTES:

- 1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37875

DART AEROSPACE LTD	Work Order:	37875
Description: SEAT PAN	Part Number:	D3022-1
Inspection Dwg: D3022-1 Rev: A		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:	EB
Date:	8-5-29

Audited by:	
Date:	08/05/25

Prototype Approval:	<i>[Signature]</i>
Date:	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

